

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006774**Date Inspected:** 15-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	You Qi Guo and Yuan Hai Gong			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as OBE 4AE+4BE. The weld designations reviewed are as follows:

Bay 6

1. OBE4A-001~005

Bay 10

SMAW welding of weld joint 95 located on SSD1-TL5H/L.

Welder is identified as Mr. Zhang Jinlong (057220). ZPMC QC is identified as Mr. Yuan Hai Gong.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-B-U2a.

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Bay 11

FCAW welding of weld joint 5A located on WSD1-TL6B/C.

Welder is identified as Mr. Liu Feng (069095). ZPMC QC is identified as Mr. Xu Le Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-4232-Tc-U4b-F.

FCAW welding of weld joint 36 located on WSD1-FDSA3-2B/C.

Welder is identified as Mr. Zheng Hua (068206). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-U4b-F.

FCAW welding of weld joint 22 located on WSD1-FDSA3-2B/C.

Welder is identified as Mr. Zheng Hua (070140). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-U4b-F.

SMAW welding of weld joint 48 located on ND1-A468-28M-1.

Welder is identified as Mr. Chen Changchun (046709). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

OBG Assembly Yard

QA Inspector observed ZPMC's personnel free hand thermal cutting of OBG Segment 1BE and 2AE Floor Beam Stiffeners.

This QA Inspector issued an incident report on the above noted noncompliance issue.

QA Inspector observed ZPMC fork lift operators dragging material (FB012-007) to storage area. QA Inspector noted material was damaged during handling.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for

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your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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